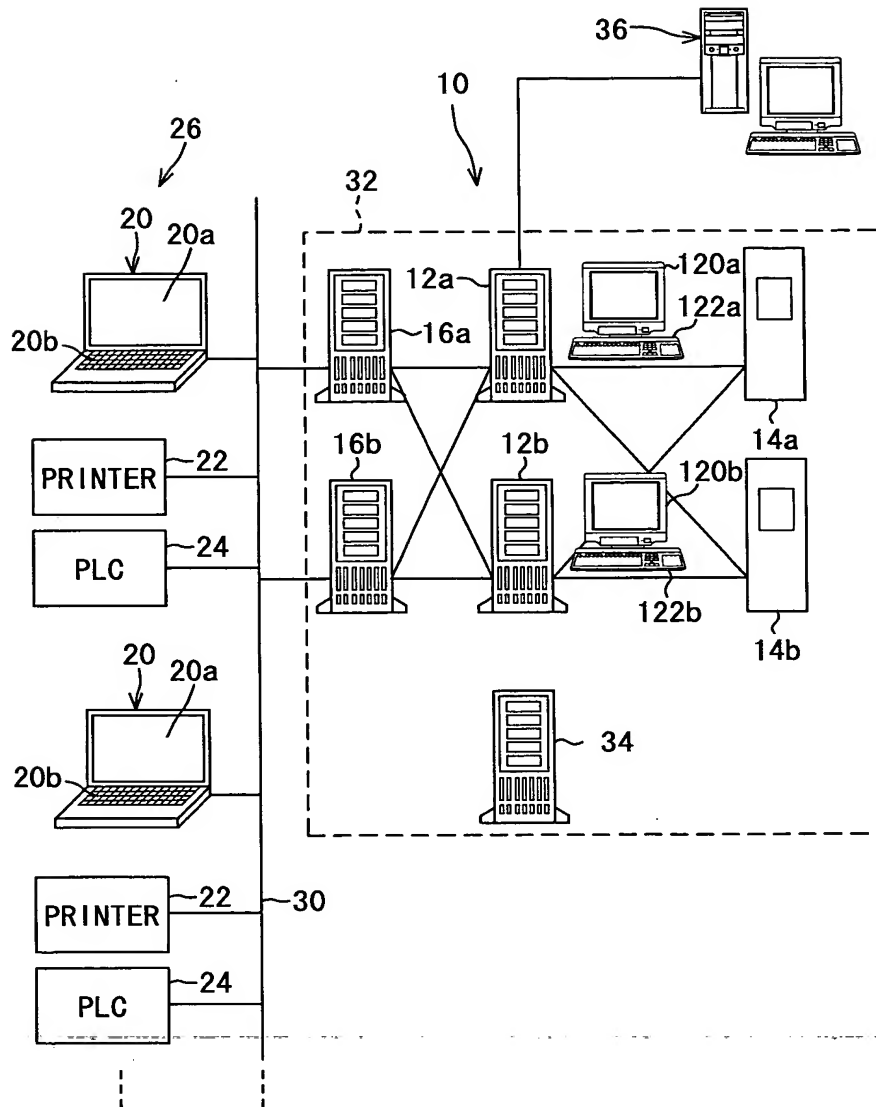
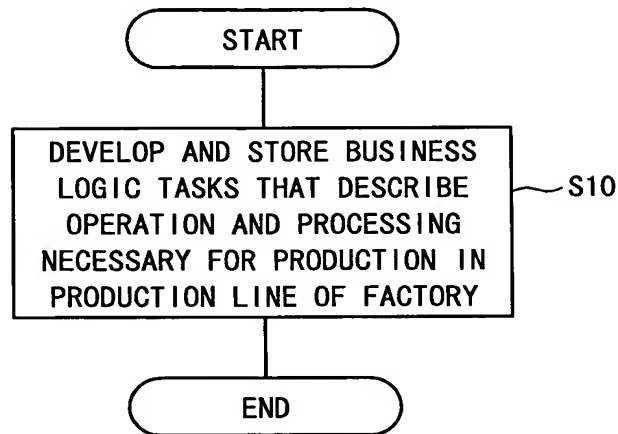


FIG. 1



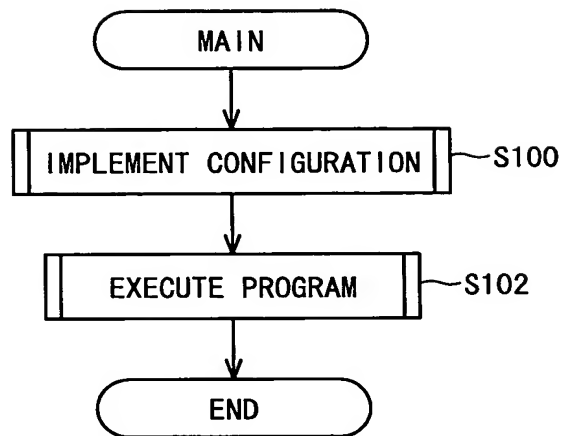
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FIG. 2



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FIG. 3



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FIG. 4

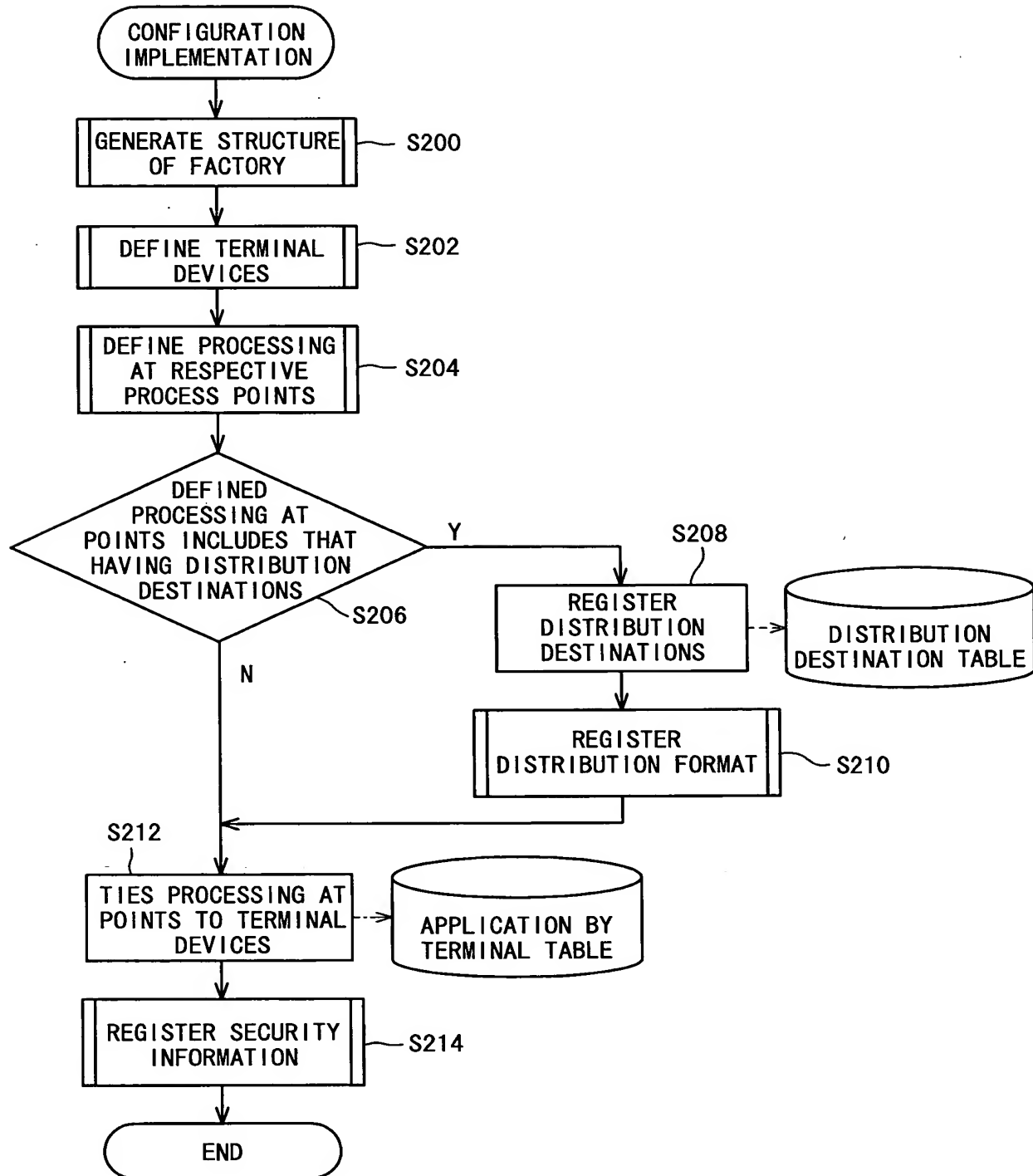


FIG. 5

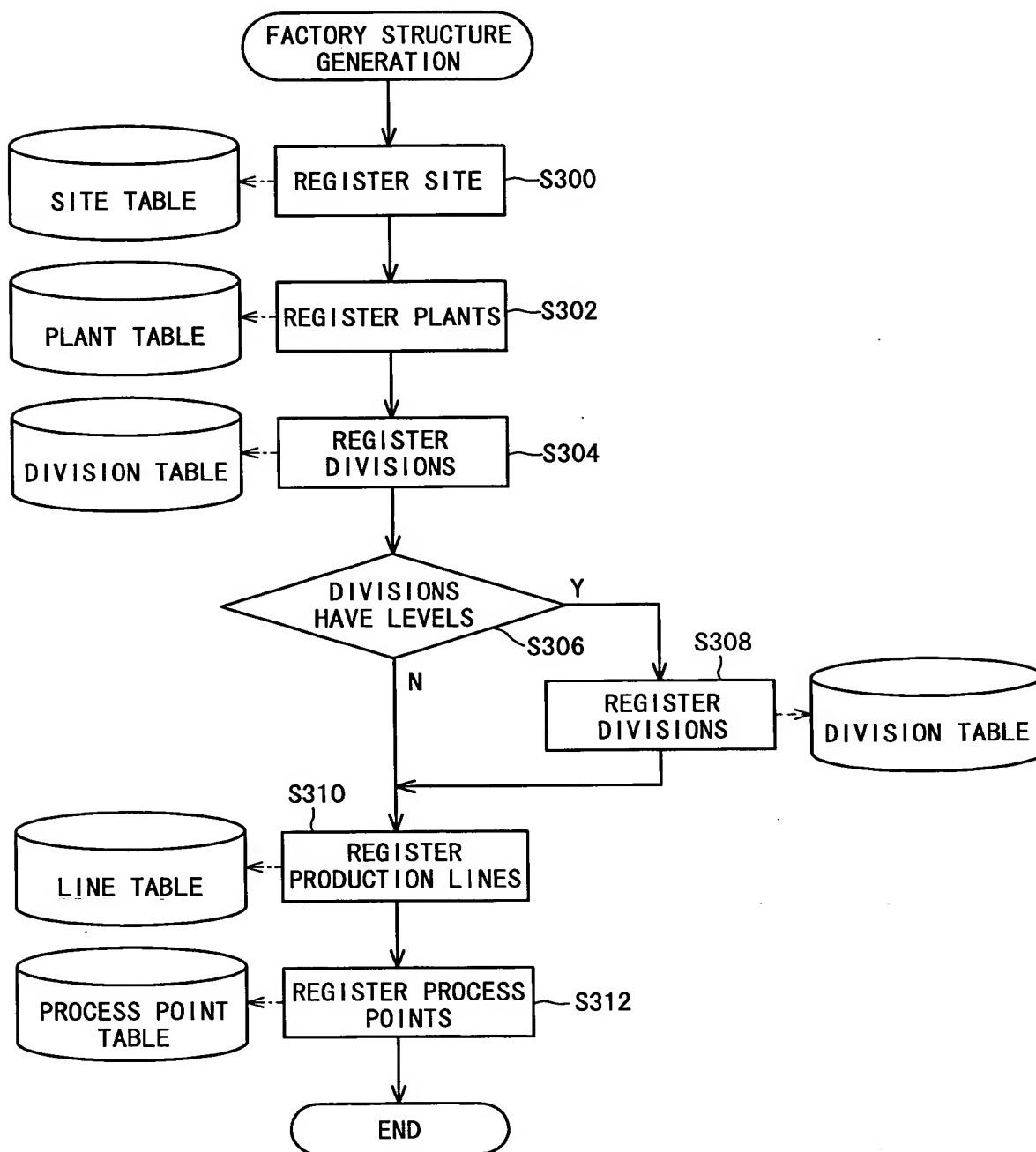
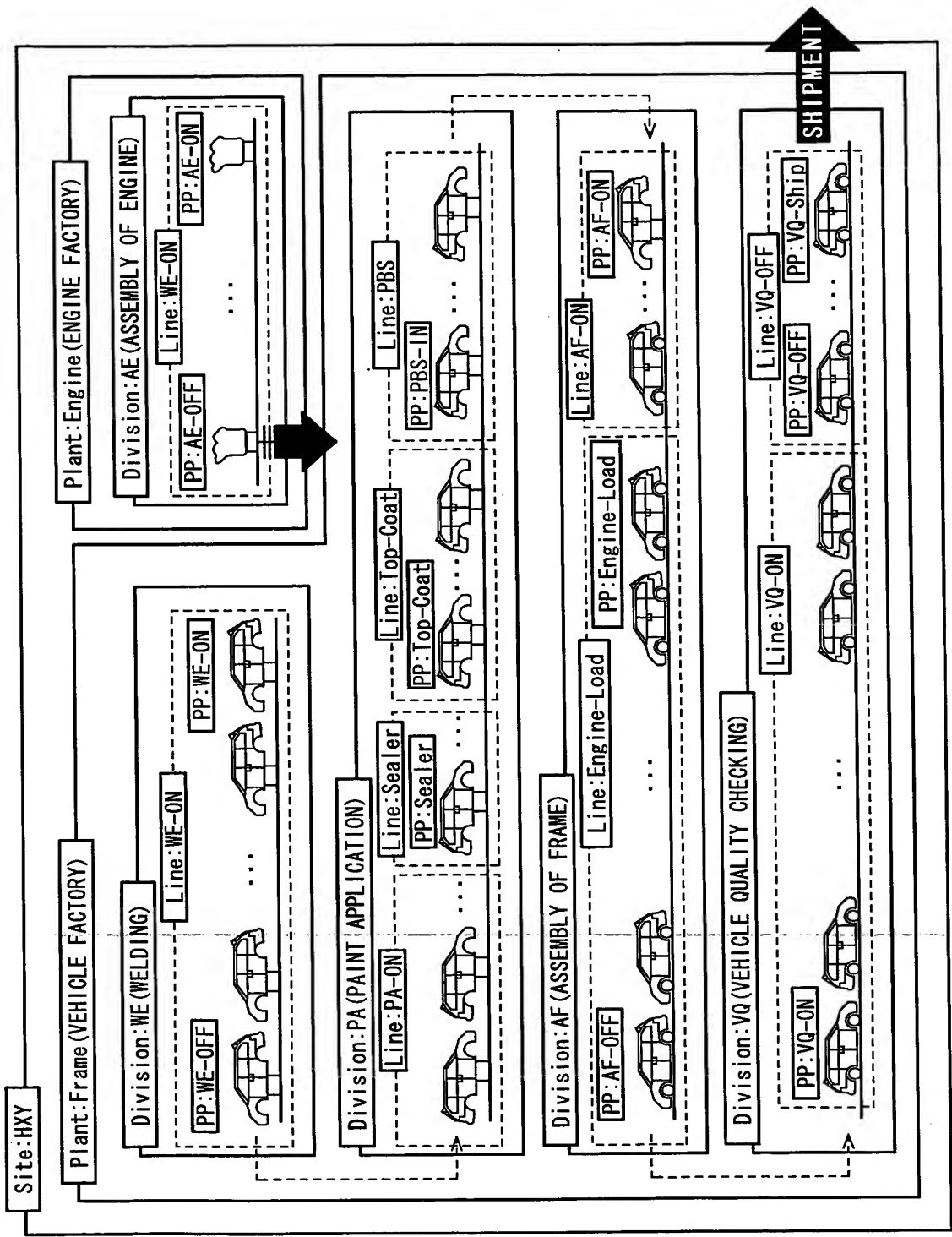


FIG. 6



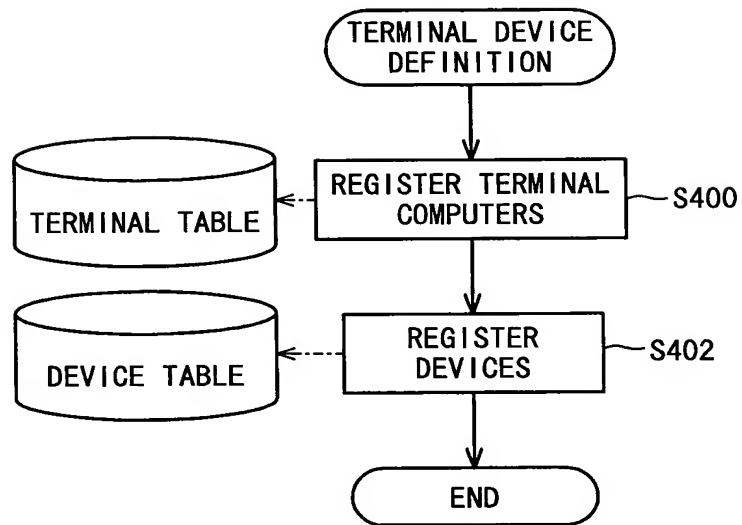
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FIG. 7

| Table | Site Name | Plant | Div. Name | Line Name | Process Point Name | Process Point ID |
|---------------|-----------|--------|-----------|-------------|--------------------|------------------|
| Site | HXY | | | | | |
| Plant | HXY | Frame | | | | |
| | HXY | Engine | | | | |
| Division | HXY | Engine | AE | | | |
| | HXY | Frame | WE | | | |
| | HXY | Frame | PA | | | |
| | HXY | Frame | AF | | | |
| | HXY | Frame | VQ | | | |
| Line | HXY | Engine | AE | AE-ON | | |
| | HXY | Frame | WE | WE-ON | | |
| | HXY | Frame | PA | PA-ON | | |
| | HXY | Frame | PA | Sealer | | |
| | HXY | Frame | PA | Top-Coat | | |
| | HXY | Frame | PA | PBS | | |
| | HXY | Frame | AF | AF-ON | | |
| | HXY | Frame | AF | Engine-Load | | |
| | HXY | Frame | VQ | VQ-ON | | |
| | HXY | Frame | VQ | VQ-OFF | | |
| Process Point | HXY | Engine | AE | AE-ON | AE-ON | PP10017 |
| | HXY | Engine | AE | AE-ON | AE-OFF | PP10205 |
| | HXY | Frame | WE | WE-ON | WE-ON | PP10038 |
| | HXY | Frame | WE | WE-ON | WE-OFF | PP10041 |
| | HXY | Frame | PA | PA-ON | PA-ON | PP10042 |
| | HXY | Frame | PA | Sealer | Sealer | PP10043 |
| | HXY | Frame | PA | Top-Coat | Top-Coat | PP10045 |
| | HXY | Frame | PA | PBS | PBS-IN | PP10138 |
| | HXY | Frame | PA | PBS | PA-OFF | PP10109 |
| | HXY | Frame | AF | AF-ON | AF-ON | PP10067 |
| | HXY | Frame | AF | Engine-Load | Engine-Load | PP10072 |
| | HXY | Frame | AF | Engine-Load | AF-OFF | PP10088 |
| | HXY | Frame | VQ | VQ-ON | VQ-ON | PP10089 |
| | HXY | Frame | VQ | VQ-OFF | VQ-OFF | PP10090 |
| | HXY | Frame | VQ | VQ-OFF | VQ-Ship | PP10096 |

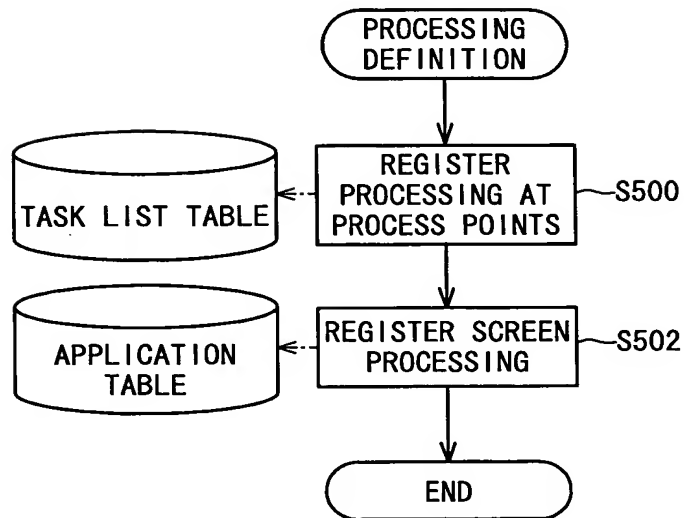
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FIG. 8



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FIG. 9



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FIG. 10

| Applica- tion ID | Seq. # | Task Name | Applica- tion ID | Seq. # | Task Name |
|---------------------|-----------|----------------------------|---------------------|-----------|----------------------|
| PP10017 | 1 | AE On | PP10072 | 1 | Scan VIN |
| PP10205 | 1 | Qics AE Repair Task | PP10072 | 2 | Engine Load |
| PP10038 | 1 | WE On | PP10072 | 3 | Distribute |
| PP10038 | 2 | Distribute | PP10088 | 1 | Scan VIN |
| PP10041 | 1 | Tracking | PP10088 | 2 | Check AF On Sequence |
| PP10042 | 1 | Bind VIN vs Smart Eye Task | PP10088 | 3 | Check Duplicate VIN |
| PP10042 | 2 | Tracking | PP10088 | 4 | AF Off |
| PP10043 | 1 | Paint Point | PP10089 | 1 | Vq On |
| PP10043 | 2 | Tracking | PP10090 | 1 | Qics VQ Task |
| PP10045 | 1 | Paint Point | PP10096 | 1 | Scan VIN |
| PP10045 | 2 | Tracking | PP10096 | 2 | Check Duplicate VIN |
| PP10045 | 3 | Count No Of Bakes Task | PP10096 | 3 | Vq Off |
| PP10138 | 1 | Point A Out | PP10096 | 4 | Tracking |
| PP10138 | 2 | Tracking | | | |
| PP10109 | 1 | Point E Out | | | |
| PP10109 | 2 | Tracking | | | |
| PP10067 | 1 | Scan VIN | | | |
| PP10067 | 2 | Check Duplicate VIN | | | |
| PP10067 | 3 | Tracking | | | |
| PP10067 | 4 | Add VIN To AFON Sequence | | | |
| PP10067 | 5 | Calc Lot Pass Task | | | |
| PP10067 | 6 | Set Factoryf News Task | | | |
| PP10067 | 7 | Bonnet Sheet Print | | | |
| PP10067 | 8 | Bonnet Sheet Print2 | | | |
| PP10067 | 9 | Distribute | | | |

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FIG. 11

| | Process Point | | | | | | | | | | | | | |
|----------------------------|---------------|--------|-------|--------|-------|--------|--------|--------|-------|--------|--------|-------|--------|---------|
| | AE-ON | AE-OFF | WE-ON | WE-OFF | PA-ON | Sealer | PBS-IN | PA-OFF | AF-ON | E-Load | AF-OFF | VQ-ON | VQ-OFF | VQ-Ship |
| AE On | ① | | | | | | | | | | | | | |
| Qics AE Repair Task | | ① | | | | | | | | | | | | |
| WE On | | | ① | | | | | | | | | | | |
| Bind VIN vs Smart Eye Task | | | | | ① | | | | | | | | | |
| Paint Point | | | | | | ① | | | | | | | | |
| Point A Out | | | | | | | ① | | | | | | | |
| Point E Out | | | | | | | | ① | | | | | | ① |
| Scan VIN | | | | | | | | | ① | ① | ① | | | |
| Engine Load | | | | | | | | | | ② | | | | |
| Check AF On Sequence | | | | | | | | | | | ② | | | |
| Check Duplicate VIN | | | | | | | | | ② | | ③ | | | ② |
| AF Off | | | | | | | | | | | ④ | | | |
| Vq On | | | | | | | | | | | | ① | | |
| Qics VQ Task | | | | | | | | | | | | | ① | |
| Vq Off | | | | | | | | | | | | | | ③ |
| Tracking | | | | ① | ② | ② | ② | ② | ③ | | | | | ④ |
| Add VIN To AF ON Sequence | | | | | | | | | ④ | | | | | |
| Calc Lot Pass Task | | | | | | | | | ⑤ | | | | | |
| Set Factoryf News Task | | | | | | | | | ⑥ | | | | | |
| Bonnet Sheet Print2 | | | | | | | | | ⑦ | | | | | |
| Bonnet Sheet Print2 | | | | | | | | | ⑧ | | | | | |
| Count No Of Bakes Task | | | | | | ③ | | | | | | | | |
| Distribute | | | | | | | | | ⑨ | ③ | | | | |

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FIG. 12

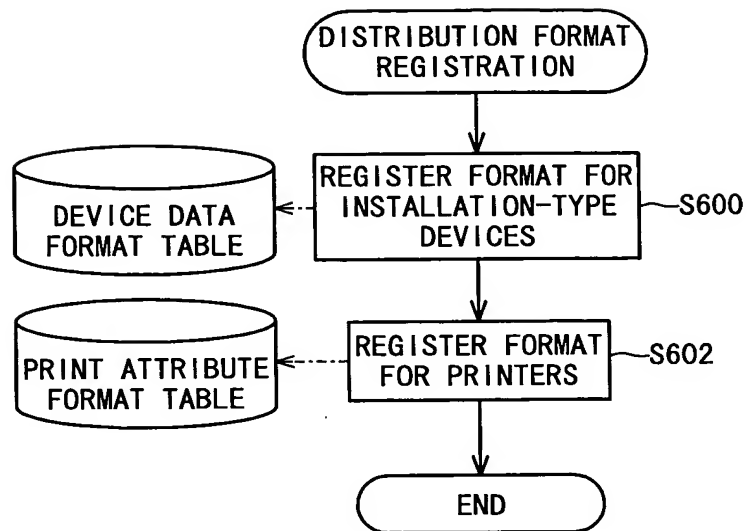
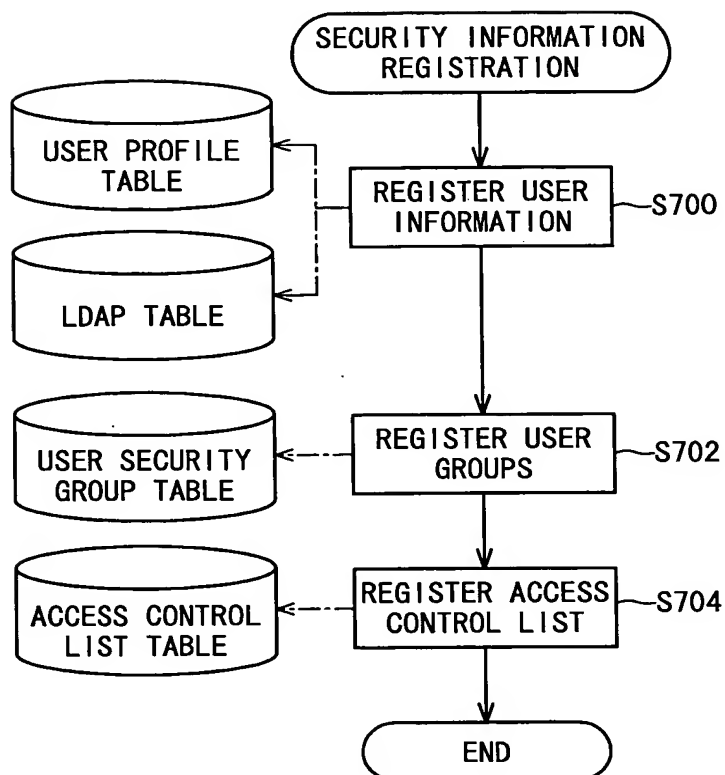


FIG. 13



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FIG. 14

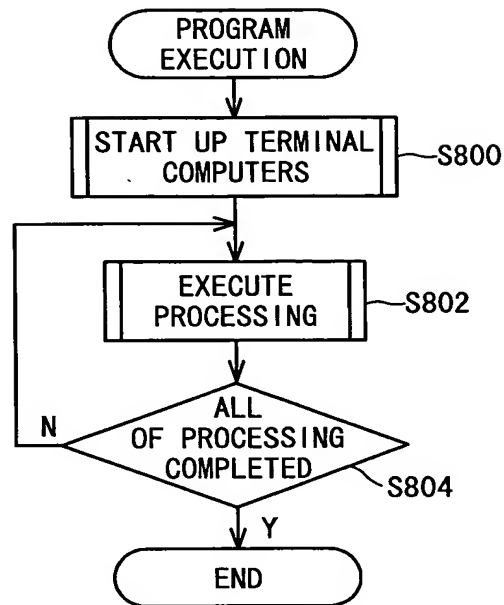


FIG. 15

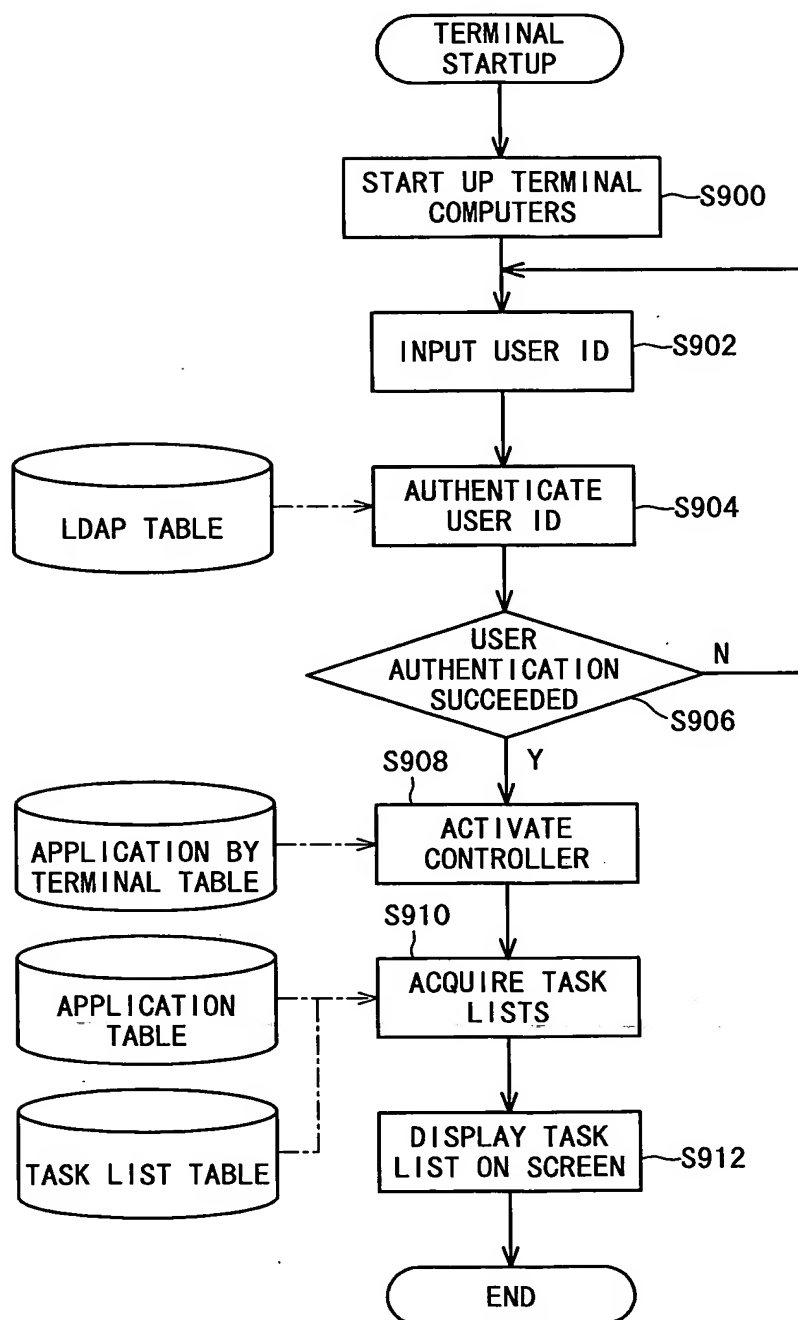


FIG. 16

